

Date: Tuesday, 17/02/2009 10:19:06 AM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: COVER
Job Number	: 45829		
Estimate Number	: 12961		
P.O. Number	:	Part Number	: D36411
This Issue	: 17/02/2009 S.O. No. :	Drawing Number	: D3641 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 11 Type : SMALL /MED FAB	Drawing Revision	: B
Previous Run	: 42298	Material	:
Written By	:	Due Date	: 24/02/2009
Checked & Approved By	: <u>09.02.17</u>	Qty:	10 Um: Each
Comment	: Est Rev:A New Issue 07-07-20 JLM Verified By:EC Est Rev:B ECN 1050 rev.b as per dwg 08-01-10 DD		

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6S032

6061-T6 Sheet 0.032"



MAT NOT PULLED



Comment: Qty.: 0.8244 sf(s)/Unit Total: 8.2436 sf(s)

M6061-T6 .032" THK sheet WRNG, MAT

SOS2 ON DRAWING

Batch: ~~110563~~

109478 IB 9-4-4

PFD

2.0

WATER JET

FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3641

Dwg Rev: B

IB 9-4-4

Prog Rev: B

(11)

2-Deburr if necessary

IB 9-4-4

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



IB 9-4-4

(11)



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



2090406 (11)



Comment: SECOND CHECK

5.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D3641-1

IB 09/04/08

(11)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-04-09	1	permt. change				<i>u</i>	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 17/02/2009 10:19:06 AM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: COVER

Job Number: 45829

Part Number: D36411

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sorlos (11)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

UND. H

09/04/09

(11)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL

09/04/09

(11)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with P/N and B/N using a permanent fine point marker, then Stock
Location 260

9/4/9

SPK

SP

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/09

(11)

Job Completion



mf 09-04-09

Dart Aerospace Ltd

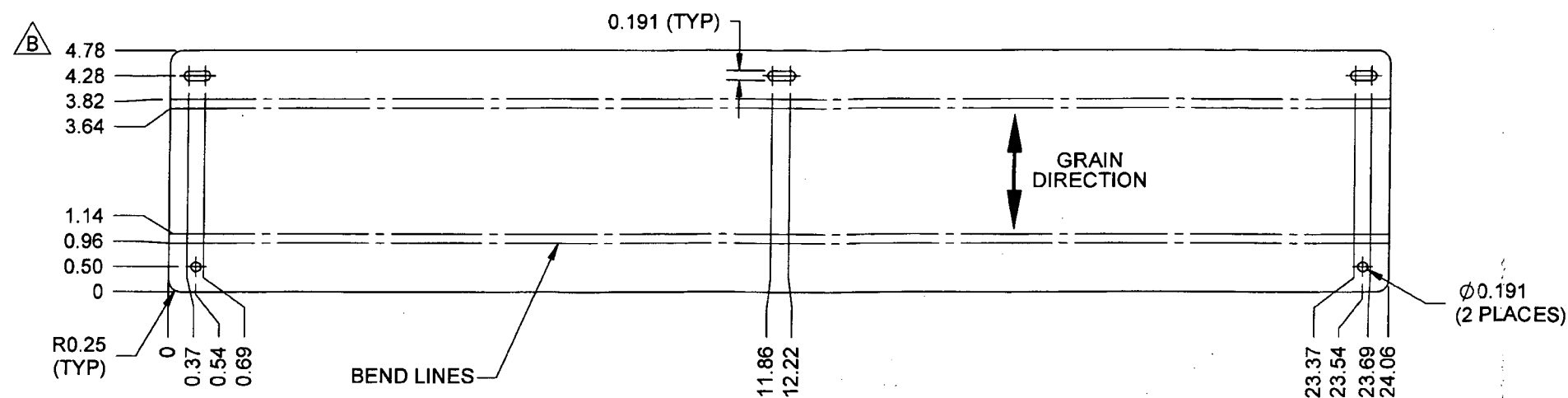
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

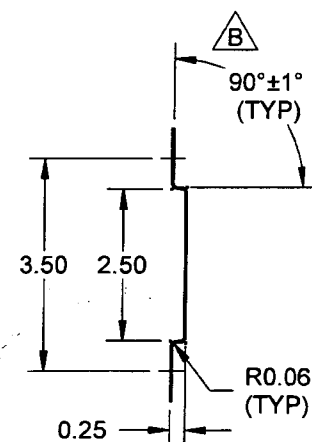
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3641-1F FLAT PATTERN



D3641-1 COVER
(REPLACES GENEVA P/N G10606-3/-6)

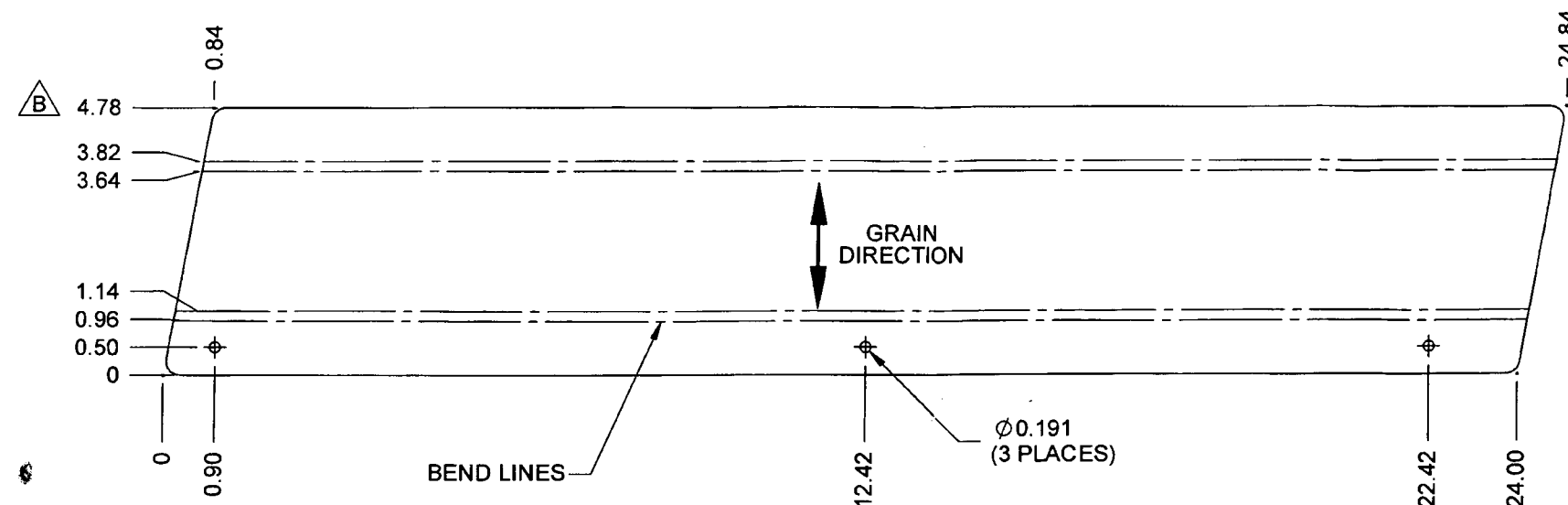
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. H5829

RELEASED
07.11.14

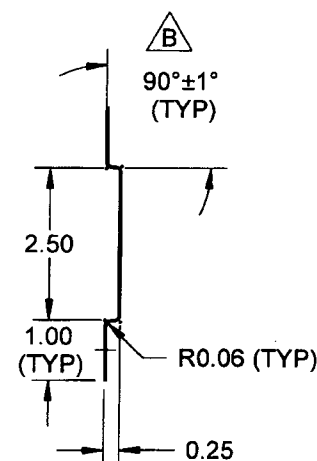
NOTES:

- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.35 lbs

B	UPDATE PROFILE TO MATCH TOOLING; GENERAL UPDATE	LE	07.10.16
A	NEW ISSUE; REPLACES G10606	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	TS	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWN	LE		
CHECKED	RA	DRAWING NO.	REV. B
MFG. APPR.	ES	D3641	SHEET 1 OF 2
APPROVED	MI	TITLE	SCALE
DE APPR.	SH	COVER	1:3
DATE	07.10.16	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



D3641-3F FLAT PATTERN



D3641-3 COVER
(REPLACES GENEVA P/N G10606-5)
D3641-4 OPPOSITE
(REPLACES GENEVA P/N G10606-4)

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER

RELEASED
 07.11.14

- NOTES:**
- 1) MATERIAL: 5052-H32 ALUMINUM 0.032 THICK PER QQ-A-250/8 OR AMS 4016 (REF DART SPEC M5052H32S.032)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3641-3/-4" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.36 lbs

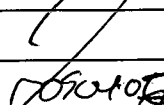
DESIGN	TS	DART AEROSPACE USA, INC.	
DRAWN	LE	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. B
MFG. APPR.	PH	D3641	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	COVER	1:3
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DART AEROSPACE LTD		Work Order: 45829
Description: COVER		Part Number: D3641-1
Inspection Dwg: D3641-1 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .191	+0.005 - .001	.193	X			
.50	+/- .030	.50	X			
4.28	+/- .030	4.282	X			
4.78	+/- .030	4.789	X			
.37	+/- .030	.37	X			
.54	+/- .030	.537	X			
.69	+/- .030	.688	X			
11.86	+/- .030	11.86	X			
12.22	+/- .030	12.22	X			
23.37	+/- .030	23.37	X			
23.54	+/- .030	23.54	X			
23.69	+/- .030	23.69	X			
24.06	+/- .030	24.06	X			
.032	+/- .010	.030	X			

Measured by: LB	Audited by: 	Prototype Approval:
Date: 9-4-24	Date: 9/4/24	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	